

Date: Monday, 16/06/2008 10:25:31 AM  
 User: Julie Lecocq

## Process Sheet

1

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
<b>Job Number</b> :	39890		
<b>Estimate Number</b> :	10939		
<b>P.O. Number</b> :		<b>Part Number</b> :	D29382
<b>This Issue</b> :	16/06/2008	<b>Drawing Number</b> :	D2938 REV C
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	39158	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	04/07/2008
<b>Checked &amp; Approved By</b> :	<u>JUL 08 16.16</u>	<b>Qty:</b>	6 Um: Each
<b>Comment</b> :	Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: B 34106

SF 08/06/24

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 5-Deburr

SF 08/06/24

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

SF 08/06/25

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

SF 08/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:31 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 39890

Part Number: D29382

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 08/06/25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MB

08/06/26

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107925

START TIME:

1:35

OVEN TEMPERATURE:

320°

FINISH TIME:

2:05

BR 08-06-26 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MB 08/06/26 (6X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

429

8/6/27

(6X)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/07

Job Completion



MF 08-06-30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39890
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.125	.125	.125	.127		
B	0.100	0.140		.125	.125	.125	.127		
C	0.100	0.140		.120	.120	.120	.121		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.131	.131	.131	.131		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.188	.188	.188	.188		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.368	1.368	1.368		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>JS</i>
Date: 08/06/24

Audited by: <i>SA</i>
Date: 08/06/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>JS</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39890
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2938-2
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

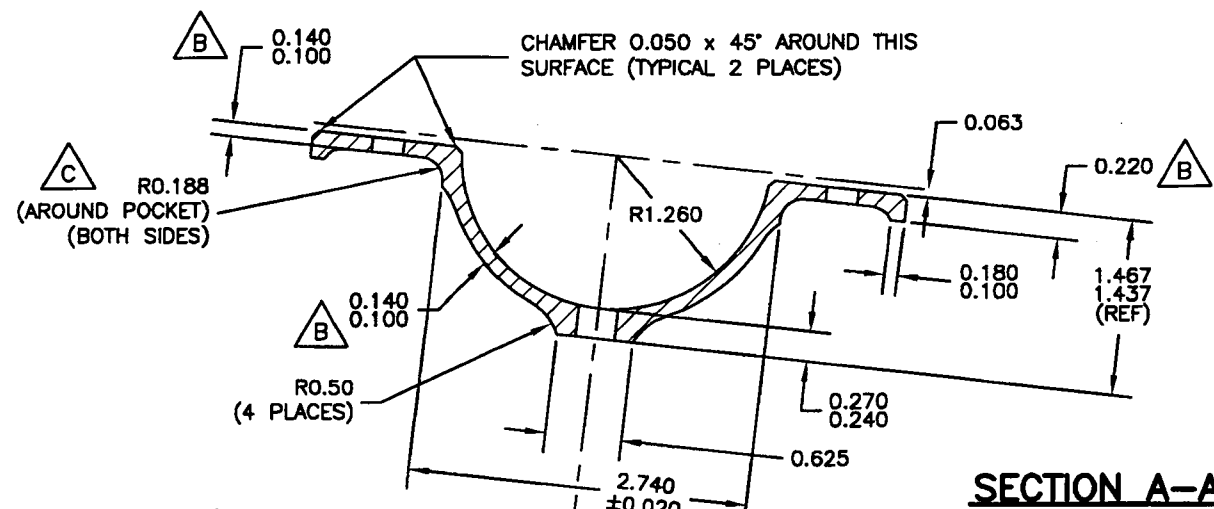
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125				
B	0.100	0.140		.125	.125				
C	0.100	0.140		.120	.120				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.578	1.578				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.259	.259				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.131	.131				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.500	.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.750	2.750				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.148	.148				
U	1.625	1.635		1.628	1.628				
V	1.362	1.372		1.370	1.370				
W	0.316	0.321		.320	.320				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

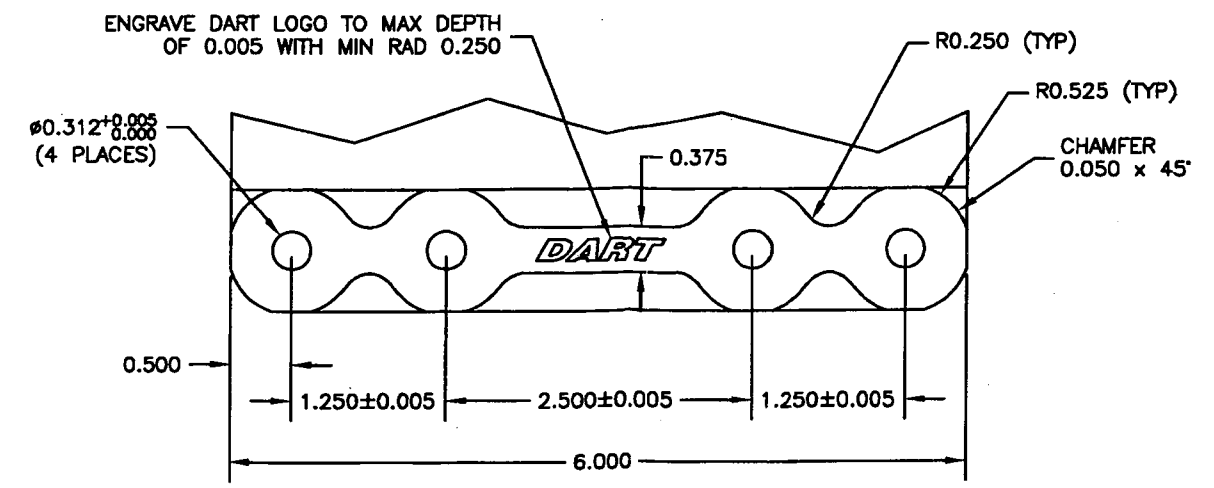
Measured by: <i>RF</i>
Date: 08/06/25

Audited by: <i>SA</i>
Date: 08/06/25

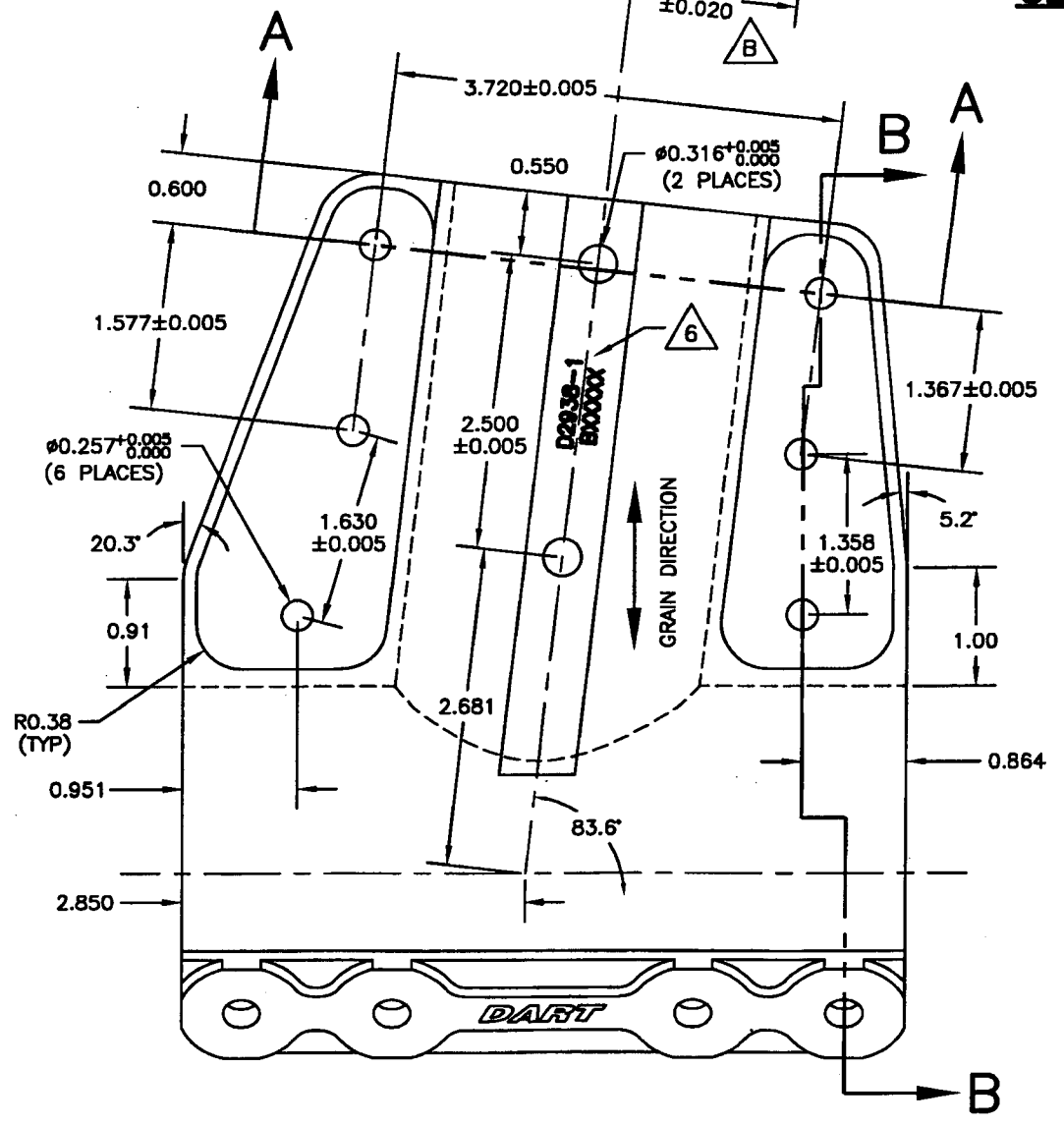
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



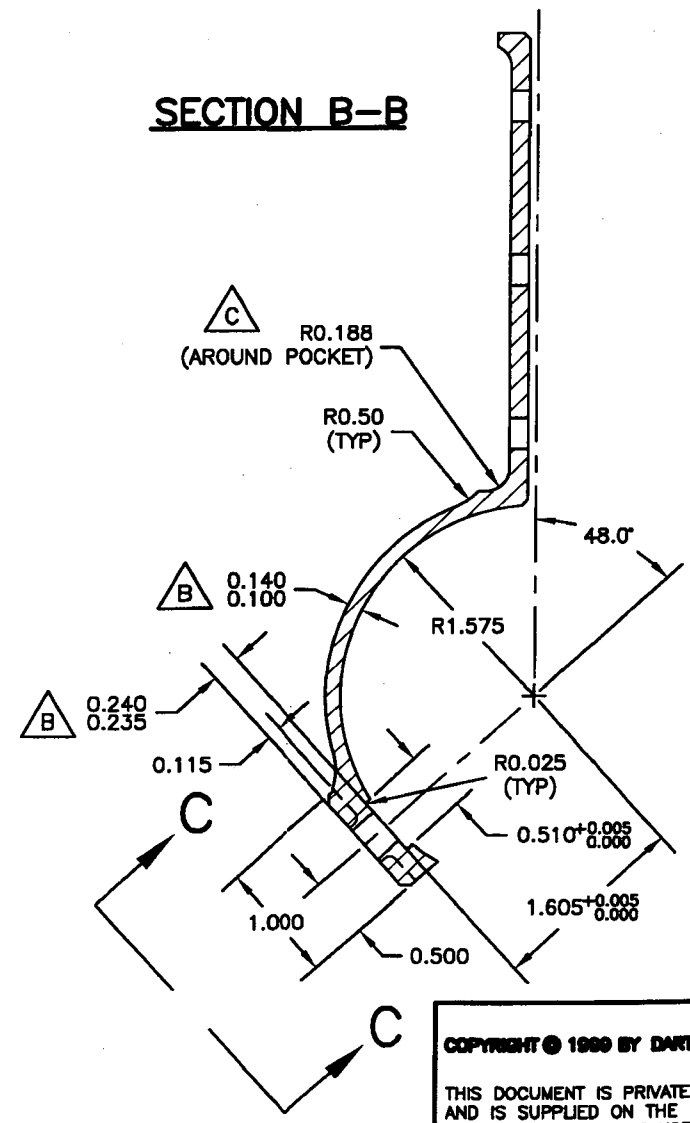
SECTION A-A



VIEW C-C



SECTION B-B



**D2938-1 LH SADDLE (SHOWN)**  
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39890

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
		DART DART AEROSPACE USA, INC. BELLEVUE, VA
		DRAWING NO. D2938
		REV. C SHEET 1 OF 1
		SCALE 2:3

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07.02.12